

Tuesday, October 15, 2013 9:03:32 AM

Ship ASAP Page 1

Revision ID:

Item Name: Mounting Lug

Start Date: 10/15/2013 Start Qty: ~~20~~ 00

Required Date: 10/18/2013      Req'd Qty: 20.00

Reference:

Approvals: Process Plan: *MMI*

QC:

Date: 3-10-15 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start \*ND1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

Set Up/  
Run Hours[illegible]

Draw Nbr

Revision Nbr

0.00

0.00

0.00

0.00

0.00

0.00

100

\*100\*

### Bandsaw

Jeaspa Bandsaw

110

\*110\*

HAAS I

HAAS CNC vertical machine #1

120

\*120\*

GC

### Quality Control

100-1-1000  
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# Work Order ID 108295

Tuesday, October 15, 2013 9:03:32 AM

\*108295\*

SHIP TODAY  
17/10

Page 3

Item ID: D2616-1

Accept

Revision ID:

\*N900040100\*

Setup Start \*NS1\*

Item Name: Mounting Lug

Stop \*NS2\*

Start Date: 10/15/2013 Start Qty: 20.00

\*20\*

Required Date: 10/18/2013 Req'd Qty: 20.00

\*20\*

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

Quality Control

222 / 211 13/10/14

170

\*170\*

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Coat bearing in light oil 2-Press Bearing in D2616-13-Stake as per Dwg  
D2616 using DT8019 4- Touch up paint if required

2 φ FF 13-10-24

180

\*180\*

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

68-6  
27  
DAS  
13-10-25

2





# Work Order ID 108295

Tuesday, October 15, 2013 9:03:32 AM

\*108295\*

Page 4

Item ID: D2616-1

Accept

Revision ID:

\*N900040100\*

Setup Start \*NS1\*

Item Name: Mounting Lug

Stop \*NS2\*

Start Date: 10/15/2013 Start Qty: 20.00

\*20\*

Required Date: 10/18/2013 Req'd Qty: 20.00

\*20\*

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

Identify as per dwg & Stock Location: ST471

0.00

\*190\*

Packaging

Memo

0.00

Packaging

2X DAS 28 13-10-25  
9-89

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

*[Signature]* 13-10-28

*[Signature]* 10-25





# Picklist Print

Tuesday, October 15, 2013 9:03:31 AM

Page 1

Work Order ID: 108295

Parent Item: D2616-1

Parent Item Name: Mounting Lug

Start Date: 10/15/2013

Required Date: 10/18/2013

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: C00.06.22 Removed P/O for powder coat EC  
IPP Rev: D 07-12-17 rev E as per dwg ECN 1069 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611 Bearing		Manufactured	No			100	Each	21.0000	1	20			

Location 108514  
ST013 ~~107711~~  
86264  
86931  
97458

Loc Qty  
21  
1  
10  
10  
Loc Code

2

FF 13-10-24

M6061T6B1.000X02.000  
6061-T6 Bar 1.00 x 2.00

Purchased No

Location  
MAT003

125258  
M126075  
M126160

Loc Qty  
120.0002  
0.0002  
96  
24  
Loc Code

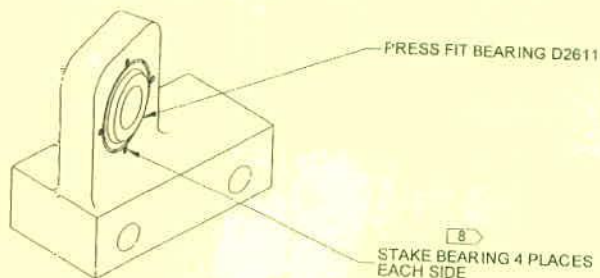
0.1666 4

4

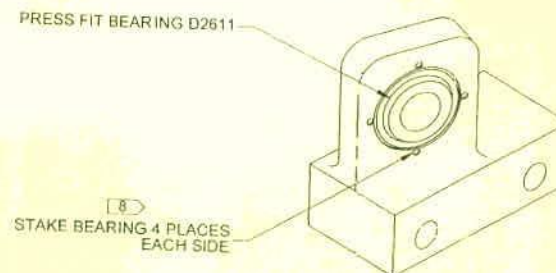
JFC 2013-10-15







**D2616-1 FWD MOUNT LUG**



**D2616-2 FWD MOUNT LUG**

QTY -1	QTY -2	PART NUMBER	DESCRIPTION
X		D2616-1	FWD MOUNT LUG
	X	D2616-2	FWD MOUNT LUG
1	1	D2611	BEARING
1		D2616-1A	LUG
1		D2616-2A	LUG

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019 TOUCH UP PAINT AFTER STAKING

#168295

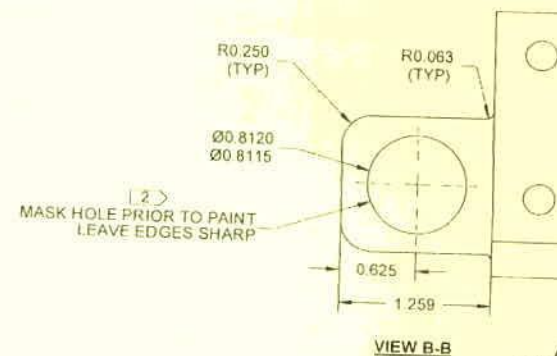
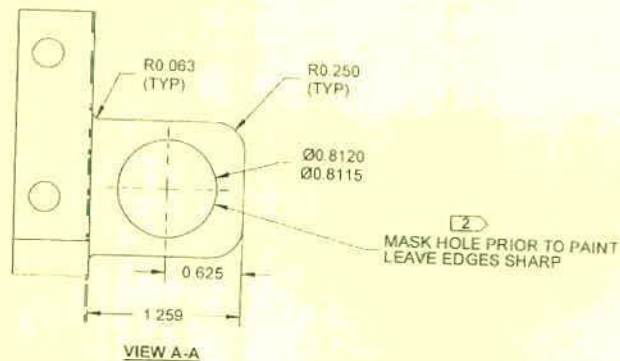
RELEASED  
07.12.22

REV.	DESCRIPTION	BY	DATE
E	UPDATE DWG. SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES	DC	07.11.22
D	D2611 WAS CBA-6 B2	KE	07.07.31
C	REMOVE D2616-3	BW	07.06.04
B	RE-DESIGN	KE	07.05.06
A	ORIGINAL ISSUE	BW	06.10.20

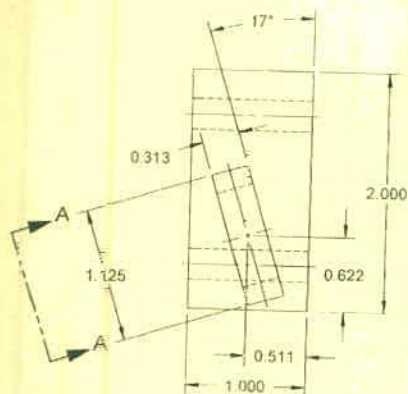
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC	DRAWING NO	REV. E
CHECKED	KE	D2616	SHEET 1 OF 2
MFG. APPR	KE	TITLE	SCALE
APPROVED	KE	FWD MOUNT LUG	1:1
DE APPR	KE	DATE 07.11.22	

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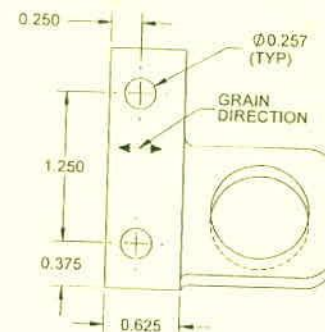
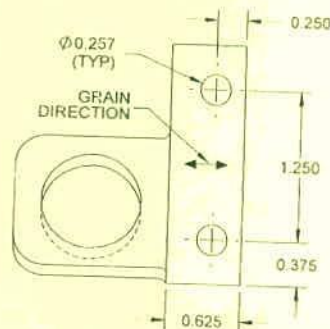




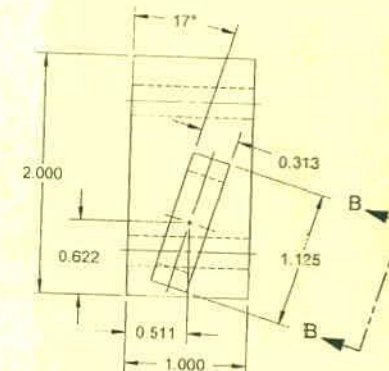
#108395



D2616-1A LUG



D2616-2A LUG



NOTES:

- 1) MATERIAL: 6061-T6 (OR 5061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
MASK BEARING HOLE PRIOR TO PAINT  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED  
07-12-12

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LC		
CHECKED	LE	DRAWING NO. D2616	REV. E
MFG. APPR.	ME	TITLE FWD MOUNT LUG	SHEET 2 OF 2
APPROVED	ME	SCALE 1:1	
DE APPR.	ME		
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED TO THE CUSTOMER ON THE CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 108295
<b>Description:</b> MOUNTING LUG		<b>Part Number:</b> D2616-1
<b>Inspection Dwg:</b> D2616 <b>Rev:</b> E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/- 0.010	0.063	✓		Ruler	JFC
R0.250	+/- 0.010	0.250	✓		"	"
0.812-0.8118	N/A	0.8118	✓		PIN/ITG	JFC-02
0.625	+/- 0.010	0.619	✓		Caliper	JFC-01
1.259	"	1.258	✓		"	"
0.313	"	0.312	✓		"	"
1.125	"	1.125	✓		"	"
2.000	"	2.003	✓		"	"
0.622	"	0.622	✓		"	"
0.511	"	0.511	✓		"	"
1.000	"	1.000	✓		"	"
0.257	+0.001/+0.000	0.257	✓		PIN	JFC
0.250	+/- 0.010	0.249	✓		Caliper	JFC-01
1.250	"	1.247	✓		"	"
0.375	"	0.375	✓		"	"
0.625	"	0.622	✓		"	"

<b>Measured by:</b> JFC	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 2013-10-16	<b>Date:</b> 13/10/12	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

